

[Name of Document]     Abstract

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[Objective]   Attention has been focused on scraps which have been traditionally discarded.   An object of the present invention is to provide a cornerplate-less duct having a rational construction, which enables the number of parts and forming steps to be significantly reduced by effectively utilizing the scraps.

[Solving means]   Plate members are joined to each other at side end portions by a seam joint structure to form a tubular duct 10 having a rectangular cross-section.

A starting end portion and a terminal end portion of a plate are bent in a direction substantially perpendicular to a longitudinal direction X of the plate to form flange forming portions 3 integral with the plate.   Corner forming portions 4 are formed integrally to protrude from side ends of the flange forming portions in a width direction to form corner portions at the starting and terminal end portions of the duct.   In an expanded shape of plate 1A or 1B, a cut portion 2 is provided closer to a center in the longitudinal direction X than a starting end 1s or a terminal end 1e of the plate member such that the cut portion 2 extends in a width direction Y of the plate member and has a depth substantially equal to an overlapping portion W1 of the corner forming portion 4.

[Selected Figure]   Fig. 1